

# Work Order ID 69494

Wednesday, May 11, 2011 1:42:17 PM



Page 1

Item ID: D2747

Accept



Setup Start



Revision ID:

Stop



Item Name: Set Screw

Start Date: 5/11/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

CL

Date: 11/05/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2747

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14061 3/8"-24 UNF SS Set Screw 7/8" to 1"  
long Possible Supplie: McMaster Carr P/N:92311A639 Material release note  
required

CL 11/05/11

100

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material release note is attached

11/05/13

100

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/11/11

counts

100

AS019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69494**

Wednesday, May 11, 2011 1:42:17 PM



Page 2

Item ID: D2747

Accept



Setup Start



Revision ID:

Stop



Item Name: Set Screw

Start Date: 5/11/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 81

0.00



Packaging

Memo

0.00

Packaging

11/5/11 100

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 100

11-05-18 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 11, 2011 1:42:15 PM

Page 1

Work Order ID: 69494

Parent Item: D2747

Parent Item Name: Set Screw



Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: B05.08.22 Reformat KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
92311A639  SS SET SCREW		Purchased	No				Each	0.0000		100		4/15/13	100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

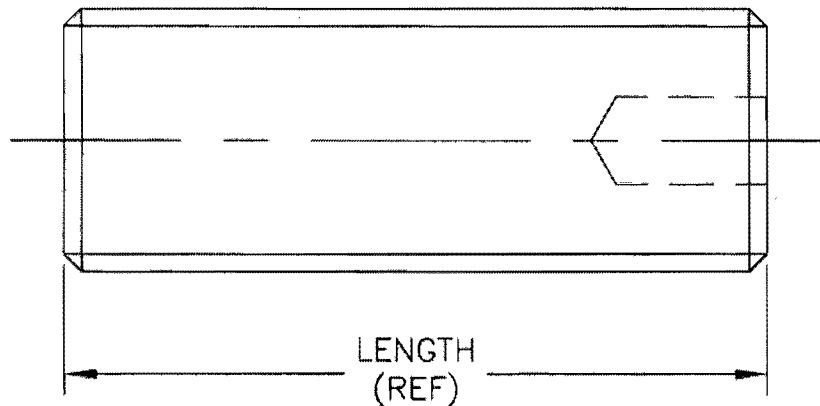
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED  
05.08.09 *[Signature]*



D2747 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*CL 11/05/11*  
*W/D: 69494*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO14061

Purchase Order Date 5/11/2011

PO Print Date 5/11/2011

Page Number 1 of 1

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

Contact Name

Vendor Phone

330 995 5500

Vendor Fax

330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
5/11/2011

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1		8795A143 1/16" E-MILL	5/13/2011 No	3.00 Each	Purolator ground	\$12.1300	\$36.39

Deliver To: JEAN-LUC

2		9516K732 PLATE	5/13/2011 No	2.00	Purolator ground	\$238.2100	\$476.42
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Deliver To: JEAN-LUC

3		3002A35 REAMER	5/13/2011 No	1.00	Purolator ground	\$26.8200	\$26.82
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Deliver To: JEAN-LUC

4	92311A639	SS SET SCREW	5/13/2011 Yes	100.00 Each	Purolator ground	\$0.6619	\$66.19
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CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Special Inst: AS PER DWG D2747 REV. B  
B69494

PO Total:

\$605.82

Change Nbr:

1

Change Date: 5/11/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



0 Aurora Industrial Parkway  
Aurora OH 44202  
0-995-5500  
sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: Deliver To Jean-Luc

McMaster-Carr Number  
6973312-02

05/12/2011

Item	Description	Ordered	Shipped
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A11

8795A143 Premium Carbide Two Flute Coated End Mill,  
Square End, TiALN Coated, 1/16" Mill Diameter,  
1-1/2" L Overall

✓ 3  
Each

Unit Price: \$12.13  
Extended Price: \$36.39

2 - 514 - 01 11 - 54 A143 3 EA 1

3002A35 High-Speed-Steel and Cobalt Steel Dowel Pin  
Chuck Reamer, High-Speed-Steel, 1/2" Pin,  
0.4995" Reamer Diameter, .4355" Shank

1  
Each

Unit Price: \$26.82  
Extended Price: \$26.82

2 - 501 3

92311A639 Type 18-8 Stainless Steel Cup Point Socket Set  
Screw, 3/8"-24 Thread, 1" Length, Packs of 10

10  
Packs

Unit Price: \$5.91  
Extended Price: \$59.10

2 - 696 4

8/11/16

arges for this shipment

Merchandise Amount:	\$122.31
Sales Tax:	\$6.12
<b>Total:</b>	<b>\$128.43</b>

t Aerospace Ltd

EXP



3 lbs  
3 lines

FW1WBP24  
05/12/2011  
06:45/07:42  
037  
Cycle 11



m  
x7x5

